



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4634-141
Job Sheet 167074-G



Part No: D4634-141

Job Qty: 1 ea

Part Name: Fwd, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/23/17

Job Tracking No:

Due Date: 11/24/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/23/17	0.00	0.00	Start up container	2017-12-13 SL
100	HandThermo	1 pcs		11/23/17	0.00	1.65	HandFinish4	12/12/18 SL
110	Small Fab	1 pcs		11/24/17	0.00	1.47	Small Fab	12/12/18 SL
120	QC	1 pcs		11/24/17	0.00	0.00	QC5	
130	Packaging	1 pcs		11/24/17	0.00	0.00	Packaging3	DEC 21 2017
140	QC21-SA	1 Ea		11/24/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-141 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: 138615 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # 138649 Expiry Date 12/01/29 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: 135435

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location:

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	- D4634-1 <u>5021569</u>	1	3	0	0
	- D4636-5 <u>5021568</u>	1	43	0	0
	- D4647-5 <u>5021567</u>	1	2	0	0
	- D4664-5 <u>5021566</u>	6	39	0	0
	- D4712-1 <u>5021565</u>	1	4	0	0
	- D4732-15 <u>5021563</u>	1	2	0	0
	- D4732-19 <u>5021561</u>	1	1	0	0
	- D5021-1 <u>5021560</u>	1	2	0	0
	- MPNY-750S-9-C <u>5021559</u>	7	570	0	0
	- MS20426AD3-4 <u>5021558</u>	4	5,055	0	0
	- MS20426AD4-6 <u>5021555</u>	2	2,797	0	0
	- MS21059L08 <u>5021554</u>	2	62	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No _____ NCR No _____ Date : _____		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com		Start up Operation Mfg Date: 12/13/17 Job No: 167074-G		<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th colspan="8">AGAINST DEPARTMENT/PROCESS</th> </tr> <tr> <td>Skid-tube</td><td>☐</td> <td>Cross tube</td><td>☐</td> <td>Water Jet</td><td>☐</td> <td>Engineering</td><td>☐</td> </tr> <tr> <td>Machining</td><td>☐</td> <td>Small Fab</td><td>☐</td> <td>Prod. Eng. Coord.</td><td>☐</td> <td>Quality</td><td>☐</td> </tr> <tr> <td>Thermoforming</td><td>☐</td> <td>Finishing</td><td>☐</td> <td>Rec/Store/Packaging</td><td>☐</td> <td>Other</td><td>☐</td> </tr> <tr> <td>Large Fab</td><td>☐</td> <td>Composite</td><td>☐</td> <td>Supplier</td><td>☐</td> <td></td><td>☐</td> </tr> <tr> <td colspan="6">QTY Effective :</td> <td colspan="2">MRB (QSI042) Approval</td> </tr> <tr> <td colspan="6" rowspan="4" style="height: 200px; vertical-align: top;">Disposition</td> <td colspan="2">Completed By</td> </tr> <tr> <td colspan="2">Lead hand / Supervisor Approval Verification</td> </tr> <tr> <td colspan="2">QC / QA Coordinator Approval</td> </tr> <tr> <td colspan="2"></td> </tr> </table>				AGAINST DEPARTMENT/PROCESS								Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐	Large Fab	☐	Composite	☐	Supplier	☐		☐	QTY Effective :						MRB (QSI042) Approval		Disposition						Completed By		Lead hand / Supervisor Approval Verification		QC / QA Coordinator Approval					
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DART AEROSPACE
S021584

Environmer _____
 Desig _____
 Doc/Da _____
 Equip/Toolir _____
 Handling/P _____
 Mater _____
 Internal Transpc _____
 Tribal Knowledge _____
 LOA _____
 Substation _____
 Past Expiry Date _____
 Misidentified _____

Rushing _____
 Product Improvement _____
 Process Improvement _____
 Manufacturing Process _____
 Past Due _____

Heat Treat _____
 Wave/Twist in Tube _____
 Marks/Chatter _____

OTHER : _____